

13776e



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2585**Job Sheet 168887****Part No:** D2585**Job Qty:** 20 ea**Part Name:** Latch Clamp**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 11/24/17**Job Tracking No:****Due Date:** 11/30/17**Created By:** Linda Lacelle**Type:** SOLD**Description:****Customer:** Helicopter Express Inc (CHEXP01)

2001 Flightway Drive Chamblee, GA, 30341 USA ph:(770) 963-6889 fx:(770) 963-7636.

Note: DWG REV B IPP D 04.02.16 Reformat; Add Receiving Step KJ/RF IPP C 06.07.21 waterjet EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/29/17	11/29/17	0.00	0.00	Start Up Waterjet		SC
100	Waterjet	20 pcs	11/29/17	11/29/17	0.00	0.51	Waterjet1		SC
120	QC	20 pcs	11/29/17	11/29/17	0.00	0.00	QC8		38
130	Brake NC	20 pcs	11/30/17	11/30/17	0.01	0.46	Brake NC 1		38
140	QC	20 pcs	11/30/17	11/30/17	0.00	0.00	QC5		38
150	Packaging	20 pcs	11/30/17	11/30/17	0.00	0.00	Packaging3	STOOR	38
160	QC21-SA	20 Ea	11/30/17	11/30/17	0.00	0.00	QC21		38

Part Op 100 - 1-Cut as per Dwg D2585
Descriptions: 130 - Form as per Dwg D2585

DAS
21
9-89

DEC 01 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S14GA	0	19	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Channel	2.590inches ± 0.010	2.600 2.580		
2	Mounting Channel	0.875inches ± 0.010	0.885 0.865		
3	Mounting Channel	0.078inches ± 0.010	0.088 0.068		
4	Mounting Channel	0.191inches + 0.005 - 0.001	0.196 0.190		

Plex 11/24/17 8:04 AM dart.lacelle.linda

DART
AEROSPACE
S013409



Latch Clamp

PART NO:
Revision:
Operation:
Change No:

D2585

Start up Operation

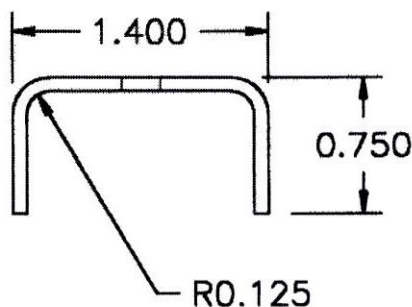
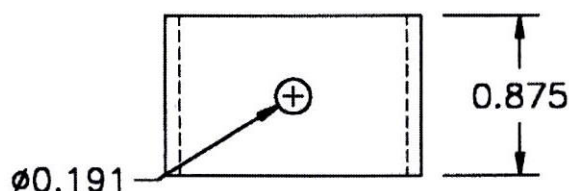
Mfg Date: 11/24/17
Job No: 168887

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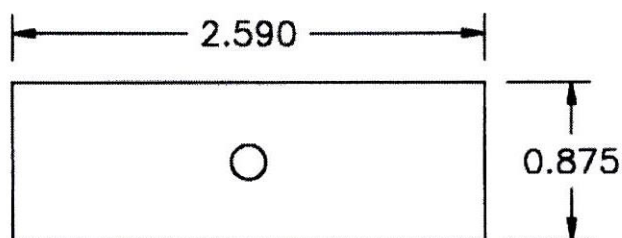


DESIGN BW	DRAWN BY MS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2585	REV. B SHEET 1 OF 1
DATE 96:07:11		TITLE MOUNTING CHANNEL	SCALE 1:1
B	97:03:14	ADD FLAT PATTERN	

RELEASED
97/03/14 DS



FLAT PATTERN



NOV 24 2017

DAS
30
9-89

MATERIAL: 304/316 SS, 14 GAUGE (0.078)

SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
168887



Dart Hawkesbury
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Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: M304S14GA Revision: 304SS sheet .080														
100	Receive sf	S013408	168887	0 sf	0	M137764	MAT020		Stock	11/24/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		1		0	0									

Plex 1/8/2018 12:38 PM Dart.Boucher.Sylvie